

Date: Wednesday, 10/11/2006 11:12:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 28919		
Estimate Number	: 11052		
P.O. Number	: <u>N/A</u>	Part Number	: D2872045
This Issue	: 10/11/2006 S.O. No. : <u>N/A</u>	Drawing Number	: D2872 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: <u>N/A</u>	Material	: <u>N/A</u>
Written By	: <u>KA 06/10/11</u>	Due Date	: 10/30/2006 Qty: 30 Um: Each
Checked & Approved By	: <u>KA 06/10/11</u>		
Comment	: Est A 05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X00750	6061T6 BAR
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Comment: Qty.: 0.2363 f(s)/Unit Total : 7.0875 f(s)
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x00.750) Batch: M18237
 Identify for D2872-5

ml 06/10/24 30

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 0.750" x 0.375" x 2.700" long

ml 06/10/24 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA550 and Dwg D2872
 Identify as D2872-5 Dwg Rev A

Folio Rev AA

ml 06/10/25 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/10/25 30

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 06/10/25 x30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:12:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28919

Part Number: D2872045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2872

ml 06/10/07

30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/06/10/30

30

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am 06/10/31

30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

ml 06/11/06

30

10.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-5

Rivet

4067

✓

11.0

MS21086L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21086L5

Nut Plate

102380

✓

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2872

2-Identify as D2872-045

ml 06/11/06

30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:12:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28919

Part Number: D2872045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/11/06

(30)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57392

10/11/07

30

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

10/11/07

Job Completion



10/11/07

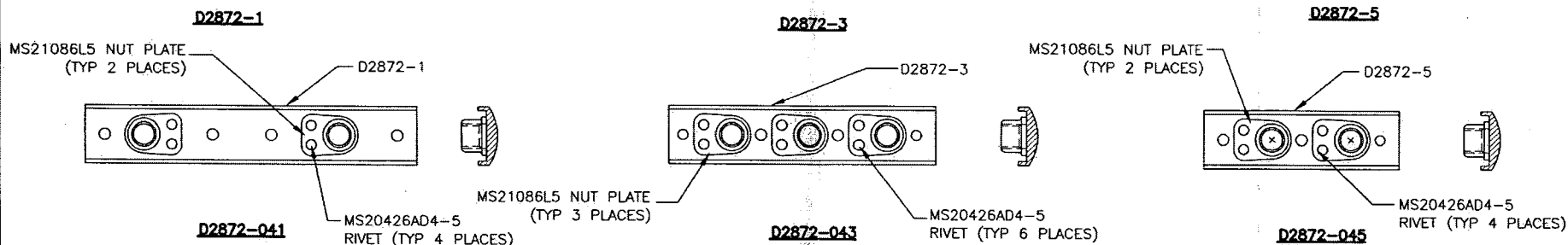
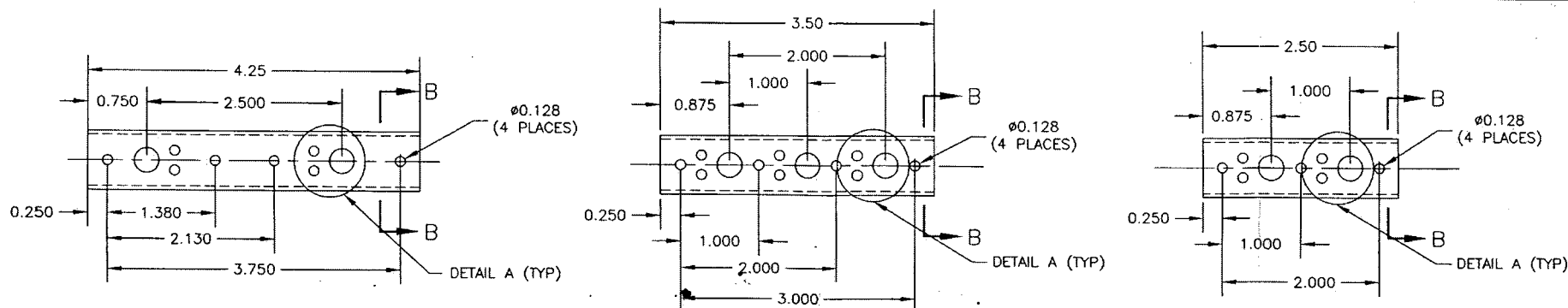
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2872-1/-3/-5 RADIUS BLOCK

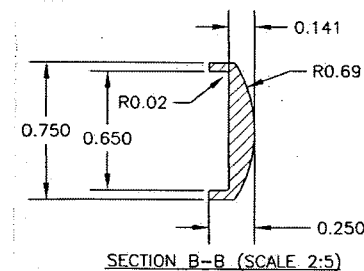
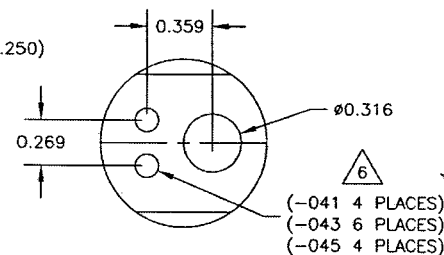
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.050$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2872-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS

D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2872-041	NUT PLATE ASSEMBLY
	X		D2872-043	NUT PLATE ASSEMBLY
		X	D2872-045	NUT PLATE ASSEMBLY
1			D2872-1	RADIUS BLOCK
	1		D2872-3	RADIUS BLOCK
		1	D2872-5	RADIUS BLOCK
4	6	4	MS20426AD4-5	RIVET
2	3	2	MS21086L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED	PH	DART
DATE	05.07.26	D2872
TITLE	RADIUS BLOCK	SHEET 1 OF 1
SCALE	4:5	

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NO. 28919
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD		Work Order: 28 919
Description: RADIUS BLOCK		Part Number: D2872-5
Inspection Dwg: D2872, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	$\pm .030$	2.499	—			
1.000	$\pm .005$	1.000	—			
0.875	$\pm .005$	0.876	—			
0.250	$\pm .005$	0.250	—			
1.000	$\pm .005$	1.000	—			
2.000	$\pm .005$	2.000	—			
$\varnothing 0.128$	$\pm .005$ $\pm .001$	$\varnothing 0.130$	—			
0.269	$\pm .005$	0.269	—			
$\varnothing 0.316$	$\pm .006$ $\pm .001$	$\varnothing 0.318$	—			
0.750	$\pm .010$	0.753	—			
0.650	$\pm .010$	0.647	—			
R0.02	$\pm .030$	R0.015	—			
0.250	$\pm .010$	0.248	—			
0.141	$\pm .010$	0.137	—			
$\varnothing 0.230 \times 0.050$	$\pm .010$	$\varnothing 0.228 \times 0.049$	—			

Measured by:	<i>mf</i>
Date:	06/10/24

Audited by:	<i>En</i>
Date:	06/10/24

Prototype Approval:	<i>QC</i>
Date:	06.10.15

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	